

Work Order ID 67859

Friday, April 01, 2011 11:54:22 AM

Page 1

Item ID: D3953-3

Accept

Revision ID:

Item Name: Gas Spring Stud, Lid

Start Date: 4/1/2011 Start Qty: 12.00

Required Date: 4/8/2011 Req'd Qty: 12.00

Reference:

Approvals:

Process Plan: *u*

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3953

C

100

0.00

ml 11.4.4

12

Doosan

0.00

Doosan Lathe

Memo

Turn as per folio FA852 & DWG

FOLIO REV: *FA*

DWG REV: *C*

DEBURR

110

QC2- Inspect parts off machine FAI/FAIB

0.00

ml 11.4.4

12

QC

0.00

Quality Control

Memo

Work Order ID 67859

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Page 2

Item ID: D3953-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Gas Spring Stud, Lid

Start Date: 4/1/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 4/8/2011 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID . Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

120

QC8- Inspect parts - second check

0.00

SL 11/04/05

(12)



QC

Memo

0.00

Quality Control

130

Identify as per dwg & Stock Location: 96

0.00



Packaging

Memo

0.00

Packaging

(12)

11/4/5 SP

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/4/5 SP

u 11.04.05

Picklist Print

Friday, April 01, 2011 11:54:19 AM

Page 1

Work Order ID: 67859

Parent Item: D3953-3

Parent Item Name: Gas Spring Stud, Lid



Start Date: 4/1/2011

Required Date: 4/8/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP RevA: New issue DD verified by:EC
per dwg revC DD 10.03.02 verified by:EC

IPP Rev:B as

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304RO.750

Purchased

No

100

f

45.9400

0.125

1.578947



304 SS Roundbar .750



11.4.4

Location

MAT028

Loc Qty

45.94

Loc Code

116501

21.86

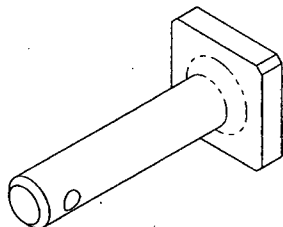
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24.08

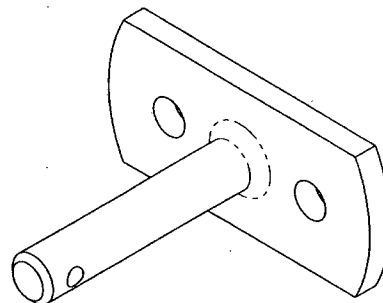
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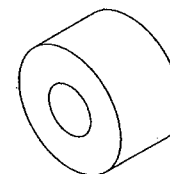
D3953-1 GAS SPRING BRACKET
(FULL LID)



D3953-3 GAS SPRING STUD, LID



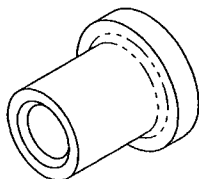
D3953-5 GAS SPRING STUD, BASE



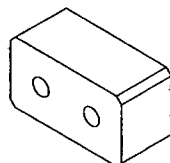
D3953-7 GAS SPRING SPACER



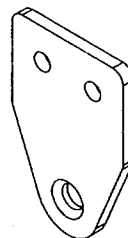
D3953-9 GAS SPRING WASHER



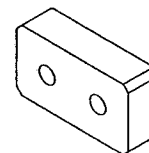
D3953-11 GAS SPRING SPACER



D3953-13 GAS SPRING SPACER
(FULL LID)



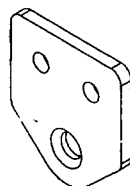
D3953-15 GAS SPRING BRACKET
(SPLIT LID)



D3953-17 GAS SPRING SPACER
(SPLIT LID)



D3953-19 GAS SPRING BRACKET
(SQUARE BASKET)

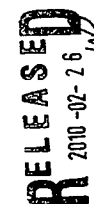


D3953-21 GAS SPRING BRACKET
(SQUARE BASKET)

RELEASED
R 2010-02-26

C	PARTS -19 & -21 ADDED (SHT 18 4); CSK CALLOUT WAS CHAM (C6-2, B6-3, C6-4); & SYMM WAS & SYM ABOUT (C7-2, C7-4); SECTION C-C REPOSITIONED TO B2-4 REASON: ADDL PARTS REQD; DRAFTING ERRORS	JPH	10.01.29
B	SHEET 3 ZONE C1, DIM 0.05 MIN WAS 0.13, MULTIPLE DIMENSIONS MIN/MAX REMOVED TOLERANCE ADDED REASON: DIFFICULTY INSTALLING COTTER PIN AT NEXT ASSY.	AJS	09.11.11
A	NEW ISSUE	AJS	09.07.27
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS		
DRAWN	JPH		
CHECKED	JP		
MFG. APPR.	B		
APPROVED	#		
DE APPR.	#		
DATE	10.01.29		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3953 REV. C SHEET 1 OF 4 TITLE GAS SPRING LID COMPONENTS SCALE NTS <small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR CHANGED OR REPRODUCED IN ANY FORM WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>			

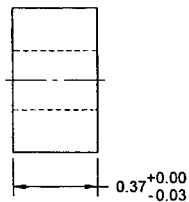
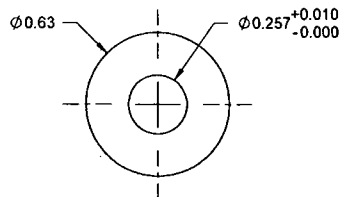
Calo 675589



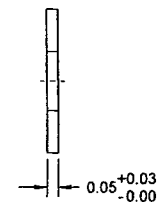
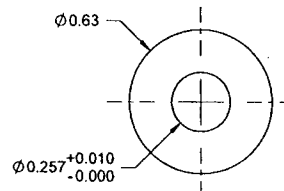
-3 & -5: AISI 304 STAINLESS STEEL BAR
REF DART SPEC M304B
OR:
AIS1 304/316 STAINLESS STEEL ROD
REF DART SPEC M304R

-5: 0.06 lbs

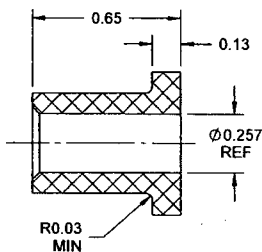
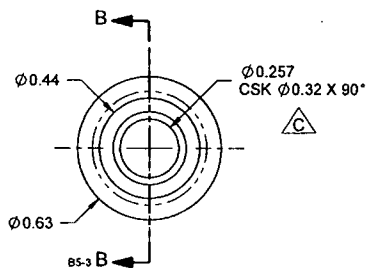
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3953 TITLE GAS SPRING LID COMPONENTS COPYRIGHT © 2009 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS RELEASED AND CONTROLLED BY DART AEROSPACE LTD. IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMERCIALIZED IN ANY OTHER PERSON WITHOUT THE WRITTEN CONSENT OF DART AEROSPACE LTD.</small>	REV.
DRAWN	JPH		SHEET 2 OF
CHECKED	<i>JPH</i>		SCALE
MFG. APPR.	<i>[Signature]</i>		NT
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>		
DATE	10.01.29		



D3953-7 GAS SPRING SPACER

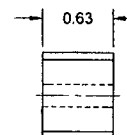
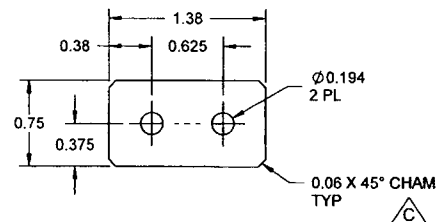


D3953-9 GAS SPRING WASHER



SECTION B-B 87-3

D3953-11 GAS SPRING SPACER



D3953-13 GAS SPRING SPACER

NOTES:

1) MATERIAL -7,-9 & -11: DELRIN II 150E OR ACETRON GP ACETAL, BLACK
REF DART SPEC M-DELIRIN-R

-13: AISI 304 STAINLESS STEEL BAR
REF DART SPEC M304B

2) FINISH: N/A

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION -13 ONLY: IDENTIFY WITH DART P/N "D3953-13" USING FINE POINT PERMANENT INK MARKER

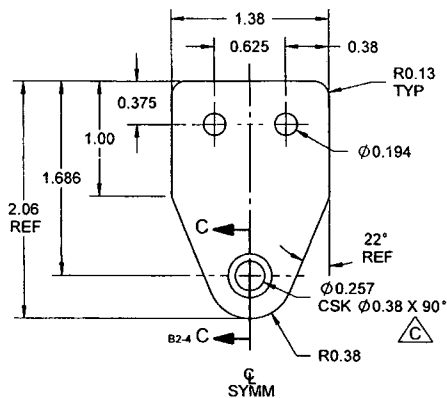
7) WEIGHT -7/-9/-11: < 0.01 lbs EACH

-13: 0.17 lbs

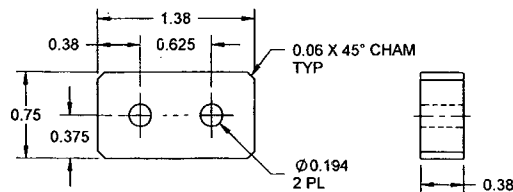
RELEASED
2010-02-26

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DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG APPR.	<i>[Signature]</i>	D3953	SHEET 3 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	GAS SPRING LID COMPONENTS NTS	
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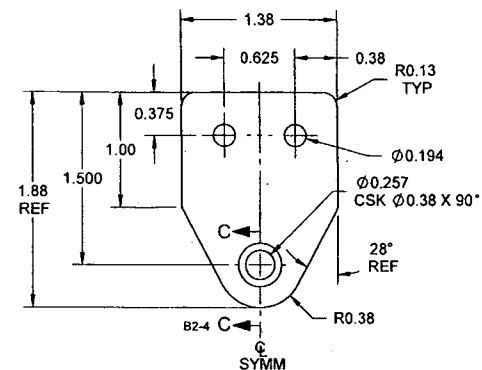
67859



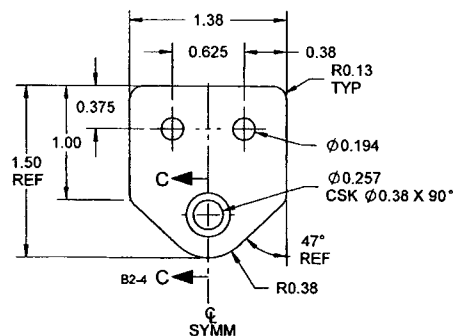
D3953-15 GAS SPRING BRACKET
(SPLIT LID)



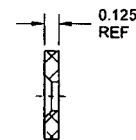
D3953-17 GAS SPRING SPACER
(SPLIT LID)



D3953-19 GAS SPRING BRACKET
(SQUARE BASKET)



D3953-21 GAS SPRING BRACKET
(SQUARE BASKET)



SECTION C-C

RELEASED
2010-02-26

- NOTES:**
- 1) MATERIAL -15/-19/-21: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 REF DART SPEC M304S11GA
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3953-X" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT -15: 0.08 lbs
-17: 0.10 lbs
-19: 0.07 lbs
-21: 0.06 lbs

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D3953	SHEET 4 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	GAS SPRING LID COMPONENTS	NTS
DATE	10.01.29	COPYRIGHT © 2009 BY DART AEROSPACE LTD	
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DART AEROSPACE LTD		Work Order: 67859
Description: Gas Spring Stud, Lid		Part Number: D3953-3
Inspection Dwg: D3953	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.75	+/-0.030	.750	/		2Q .02	
0.56	+/-0.010	.862	/			
0.281	+/-0.010	.281	/			
1/4-28 UNF-2A	N/A	2A	/			
Major Ø	Max = 0.2490 Min = 0.2425	.246	/		2Q .06	
M.O.W.	Max = 0.26687 Min = 0.26357	.265	/		2Q .06	
Ø0.098	+0.004/-0.001	.098	/		2Q .02	
Ø0.250	+/-0.010	.246	/			
0.170	+/-0.010	.170	/			
0.330	+/-0.010	.330	/			
0.13	+/-0.030	.133	/			
R0.06	+/-0.030	.060	/			
1.31	+/-0.030	1.316	/			

Measured by: [Signature]	Audited by: SL	Prototype Approval: N/A
Date: 11-4-4	Date: 11/04/05	Date: N/A

Rev	Date	Change	Revised by	Approved
A	09.10.22	New Issue	KJ	
B	09.12.14	Dwg Rev updated	KJ [Signature]	[Signature]